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JAPANESE PATENT OFFICE

PATENT ABSTRACTS OF JAPAN

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(71) Applicant: ZUIKOU:KK

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(72) Inventor: WADA TAKAO

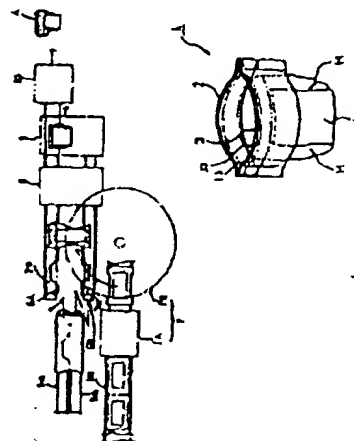
(54) MANUFACTURE OF BRIEFS TYPE DISPOSABLE
DIAPER

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(57) Abstract:

PURPOSE: To reduce costs by enabling an automatic large-scale production method by forming a back body wrapping part and front body wrapping sections to place a diaper main body thereon orthogonally and to bond it thereto.

CONSTITUTION: Optional stock is selected for a back body wrapping section and front body wrapping sections (2 and 3) independently of diaper body 1. In other words, the diaper body 1 is relayed to a turning transfer device 7B behind a suction conveying device 7A and the diaper body 1 is turned by 90 to be supplied to a specified position between belt bodies 2a and 3a of both body wrapping sections perpendicular thereto. Then the diaper body is conveyed to a bonding means 8 to bond it integrally with the belt bodies 2a and 3a of both body wrapping sections. Thereafter, the assembly is conveyed to a folding means 9 to be folded double and side ends of the belt bodies 2a and 2b of both the body wrapping sections are cut while being bonded by a bonding/ cutting means 10.



full translation attached
No equivs. outside Jppon

Translation of
Japanese laid open patent application number H3-176053

Japanese Patent Office (J P)

LAID OPEN PATENTS GAZETTE (A)

Laid open patent application number H3-176053

Laid open July 31, 1991

INT. C1^s A 61 F 13/15
5/44

Identification code H

Internal office filing numbers 7603-4 C

6606-3B A 41 B 13/02 S

Examination request	not requested
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Number of claims	1
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(total of 6 pages [in the Japanese])

Title of the invention Brief-type disposable diaper production
method

Patent application number H1-315742

Application date: December 4, 1989

Inventor

T. Wada

c/o K.K. Zuiko

15-21 Minami Beppu-cho,

Settsu-shi, Osaka-fu -

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Applicant K.K. Zuiko
 15-21 Minami Beppu-cho,
 Settsu-shi, Osaka-fu

Agent Patent attorney F. Okumura

Specification

1. Title of the invention

Brief-type disposable diaper production method

2. Scope of the patent claim

A brief-type disposable diaper production method involving

a process whereby a water-absorbent material is inserted between an outer sheet and an inner sheet to form a diaper body;
a process whereby a front waistband and a continuous back waistband having an elastic member at least at the side is formed;

a process whereby the diaper body is overlapped and adhered to both waistbands in the transverse direction;

a process whereby the diaper body is folded double and both waistbands are brought into contact; and

a process whereby the contacted waistbands are cut to prescribed dimensions and the regions near the cuts are adhered to integrate the waist parts at the edge portions

to produce a brief-type disposable diaper from a diaper body and a single waistband.

3. Detailed description of the invention

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Field of industrial use

The present invention relates to a brief-type disposable diaper production method.

Prior art

Known technology relating to this type of brief-type disposable diaper production method is disclosed in Japanese Unexamined Patent Application Number S57-77304: "Diaper-brief and Production Method Therefor".

Problems to be overcome by the invention

The abovementioned technology is disadvantageous in that as there is a cut-out portion in order to form an opening for the wearer to insert his/her legs, it is necessary to add a process for forming the cut-out portion, which raises production costs.

Means of overcoming the abovementioned problem

The present invention overcomes the abovementioned problem of the prior art and allows the production of brief-type disposable diapers by an automated large-scale production method involving a process whereby a diaper body is formed; a process whereby a back waist part and front waist part are formed; a process whereby the diaper body is overlapped and adhered to both waist parts in the transverse direction; and a process whereby the diaper body is adhered and integrated.

Embodiment

The present invention is described in detail based on the embodiment shown in the following drawings.

Figures 4 through 6 show an example of a brief-type disposable diaper produced according to the present invention: 1

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represents the diaper body, formed by inserting absorbent material 13 between outer sheet (for example, a water-impermeable P.E. sheet) 11 and inner sheet (for example, water permeable nonwoven cloth) 12.

2 is the back waist part and 3 is the front waist part, and the material for both waist parts 2 and 3 may be selected independently from the material for diaper body 1, although in this embodiment, the same material is used; the double layer having P.E. sheets 21 and 31 as the outside and nonwoven cloth 22 and 32 as the inside is formed, an elastic member sheet (for example, a polyurethane sheet) 23 and 33 is inserted into part thereof, so that at least the upper edge is expandable. It should be noted that it is also possible to have a single layer elastic sheet, to form a completely expandable construction. It should be noted that as waist parts 2 and 3 are preferably of an air-permeable material, it is desirable either to take the nonwoven cloth and elastic sheet, and exclude the P.E. sheet, or, when a P.E. sheet is used, to puncture a plurality of small holes therein. It is also possible to totally or partially affix the elastic member (rubber thread, rubber tape or the like) to a sheet of suitable material, to form an elastic sheet.

Moreover, the hole parts H for the insertion of the wearer's legs are dictated by the width and shape of the diaper body 1 and the width and shape of waist parts 2 and 3, and generally, the shape is such that the holes are toward the front side.

The brief-type disposable diaper production method of the

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present invention will be described below with reference to Figures 1 through 3.

Figure a shows the diaper body 1 production process: absorbent body 13 is placed on outer sheet (back sheet) 11 supplied from outer sheet roller 11a, then inner sheet (top sheet) 12, supplied from inner sheet roller 12a, is supplied thereon, to achieve a sandwich-like insertion of absorbent body 1 between outer sheet 11 and inner sheet 12; then this is transported by the first conveyor device 4 to adhering-cutting device 15, and the circumference is firmly adhered by adhering-cutting device 15, or adhered with adhesive, then cut to the required shape. It should be noted that this process is the same as known diaper production processes, and it is possible to employ a conventional production line for disposable diapers.

It should be noted that the adhering-cutting device 15 comprises two stages: first unit 15a and second unit 15b. In first unit 15a, only adhesion and the cutting of cut-away parts P proceeds, to continuously form diaper body 1, then diaper body band 1a is transported to the next process, and may be cut crosswise to the required dimensions by second unit 15b when in the vicinity of the waistbands 2,3-adhesion process.

Moreover, as there are no cut-away parts P when diaper body 1 is long, it is also possible to achieve the aims of the present invention by only adhering in first unit 15a, then cutting in second unit 15b.

There are various possible shapes for the cut-away parts P, and the shape can be selected according to the shape of the

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waistband 2,3 and the desired shape of hole parts H.

Figure 1(b) shows a waistband 2, 3 production line: elastic member sheet 23a, supplied by elastic member sheet roller 14, is cut along a continuous S-shaped cutting line in the central portion by cutting device 24 to form a pair of bands, back waistband 2a and front waistband 3a.

It should be noted that in the case of the multilayer constructions shown in Figure 3 (outer sheet (P.E. sheet) and elastic member sheet, inner sheet (nonwoven cloth) and elastic member sheet, or outer sheet and elastic member sheet-inner sheet), if elastic member sheet 23a is a band of the same width, and only part of sheet 21a, 22a is adhered, the elastic member sheet can be used effectively without cut-away parts, and holes of the desired shape can be found by selecting a suitable shape for waist part 2,3.

Figure 1(c) integrates the diaper body 1 process of Figure 1(a) and the waistband 2a, 3a process of Figure 1(b), to show the brief-type disposable diaper-forming process: the second conveying device 5a, 5b for waistbands 2a, 3a extends to become the third conveying device 6A and the force conveying device 6B.

Diaper body supply means 7 comprises suction conveying device 7A and rotation conveying device 7B, such that suction conveying device 7A for conveying the diaper body 1 that has been cut to the required dimensions is provided at the end of the first conveying device 4, after which diaper body 1 proceeds onto rotation conveying device 7B, then rotation conveying device 7B rotates the diaper body 1 through 90°, to supply diaper body 1

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transversely to a prescribed position on waistband 2a, 3a.

It should be noted that rotation conveying device 7B receives the diaper body 1 on the conveying surface of suction conveying device 7A then supplies it by rotating 1/4 of a rotation while suction continues, then rotating the diaper body 1 that is between third conveying device 6A and fourth conveying 6B through 90°, and diaper body supply means 7 can achieve the aim by means of a suitable conveying means as follows: the adsorption surface of the diaper body is rotated through 90° according to the rotation of a suction rotation drum provided so as to be continuous with suction conveying device 7A, then the diaper body proceeds to a suction conveyor belt, whereupon it is conveyed in a transverse direction with respect to the conveying devices, thereby allowing diaper body 1 to be supplied between waistbands 2 and 3.

Diaper body 1 is then conveyed to adhesion means 8 and adhered to waistbands 2a, 3a by a suitable adhesion means such as an adhesive or heat seal.

It is then conveyed to folding means 9, and folded double by said folding means 9 to superimpose front waistband 2a and back waistband 3a.

The sides of the superimposed waistbands 2a and 2b are adhered and cut to the required shape by adhering-cutting means 10, to yield brief-type disposable diaper A.

Advantages of the invention

The present invention yields a brief-type disposable diaper by adhering and integrating a pair of waistbands and a

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diaper body and cutting to the required dimensions and so conventional diaper production lines can be used for the diaper body, the waist parts are supplied as bands and automated mass production is possible due to a belt conveying device, so the brief-type disposable diapers can be effectively produced at extremely low cost.

4. Brief description of the drawings

Figure 1 is an explanatory diagram for the brief-type disposable diaper production method of the present invention: Figure (a) shows the diaper body production process, and Figure (b) shows the waistband-integrating process.

Figure 2 is a diagram of the diaper body, and Figure 3 shows the front waist part and back waist part.

Figure 4 shows an oblique view of a brief-type disposable diaper produced according to the present invention, Figure 5 is plane view and Figure 6 is a cross-sectional view of the diaper body.

- | | |
|----|--------------------------|
| 1 | Diaper body |
| 2 | Back waist part |
| 3 | Front waist part |
| 7 | Diaper body supply means |
| 8 | Adhesion means |
| 9 | Folding means |
| 10 | Cutting means |

Applicant K.K. Zuiko

Patent attorney

S. Okumura

特開平3-176053(3)

ブリーフを用いて与えらるべき工程を示し、 b 口弁開閉の工程を $a \cdot 3$ の第 2 項に置き、 $a \cdot 5$ の係数を減じて再び温度調整 a 及び第 4 項に置き a とする。

測り強道より多くの材料に、測定方法に必要と
 れたおむつを1を製造するための吸引装置製造
 7人を超え、その後方の延綿製造装置7名におむ
 つを1を引取り、延綿製造装置78でおむつを
 は1を9日産出する生産体制が運用されてきた。こ
 れらの測定装置に必要設備でおむつを1を供給
 して、おむつを供給する手段を構築する。

次に、圧縮機送風量78は吸引機送風量7Aの
 風通面との面積比を1を定取り、吸引しつつ
 1/4倍にして第3風通面8Aと第4風通面
 8Bとの間における面積比を0.0度以内とせしめ
 るものであるが、吸引機送風量7Aに接続し
 て吸引機ドラムを回してドラムの周囲に排
 気しつつ面積比を0.0度以内とせしめ
 たのも吸引機ドラムに接続する吸引機ドラムと
 風通面8Aと風通面8Bとを接続しても、面積比を

(1) 本機内リ線は第2・3段に接続であるものであり、第2・3段は機械的故障は通常の用途等により発生を防止することが出来る。

次に得点手段もへ贈送した後、ヒートシール、
得点手段の送達の際に手段により、多量に送つて
を何となく送り添付枚数24・36と送りして一様
化する。

そのうち、例題みずのうへを流し、例題みず
のうへにより二例題に例題けて例題例題り例題例題
2と例題例題り例題例題は3とと手数を合わせて6

雪の降つた所、四圍静寂。故に2・2の同
様現象。同音可成平致しにより推定するとどら
に、所定北に明顯して、ブリーフお使い用でま
なづ人を驚かす。

○ 漢 字 の 書 法

本発明は、一片の鋼線り紙を女性と、おむつ工
体とを、接着一体化し、所定すばに形成すること
により、ブリーフ形使い捨ておむつを形成するも
のであるから、おむつ工体は従来のおむつ製造ラ
インを利用することができ、また鋼線り紙は薄紙

10 -- 一切無半段

代理人 株式会社 尾 光
代理人 野村士 尾 光

ことで供給されることで、ベルト製造装置による大
 量生産製造方法とすることができ、そのために低
 コストでブリーフ製造に用いられることを可能にする
 装置を開発するものである。

4. 國語の教學法展開

第1回は基礎知識によるブリーフ作成の指導と、その
次の課題方法を示す説明図で、4回は各ブリーフ基本
の製造工程、5回は例題の解説との一歩化工程を示
れり、他は予備事項である。

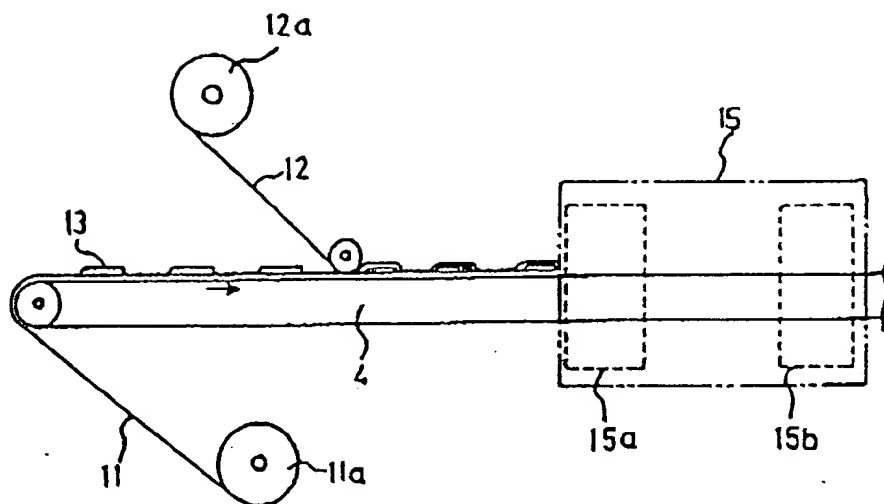
第2圖は8㍻つ本位の図面図、第3圖は尺面圖
圖の5㍻とび尺面圖圖の5㍻の図面図である。

第4図は五葉樹により製造されたブリーフ紙の
いびでおむつの断面図、第5図は平面図、第6図
は五葉樹おむつの断面図である。

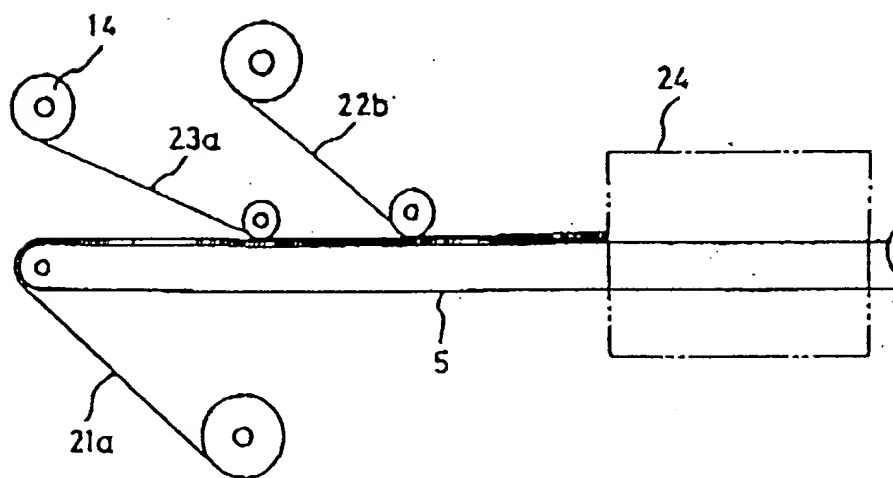
- 1 --- ひとつ五銭
- 2 --- 二個四角五分
- 3 --- 三個三角五分
- 7 --- 七個一圓五角
- 8 --- 八個一圓
- 9 --- 九個八角

特開平3-176053(4)

第1図 (a)

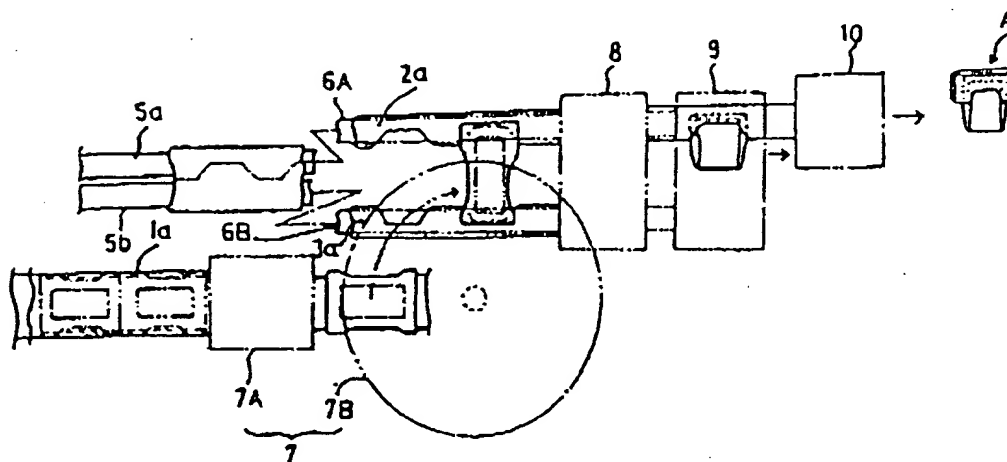


第1図 (b)

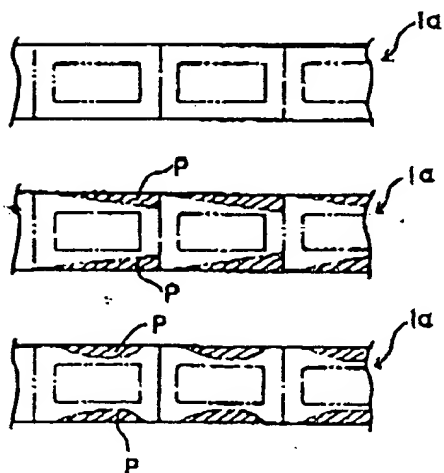


特開平3-176053(5)

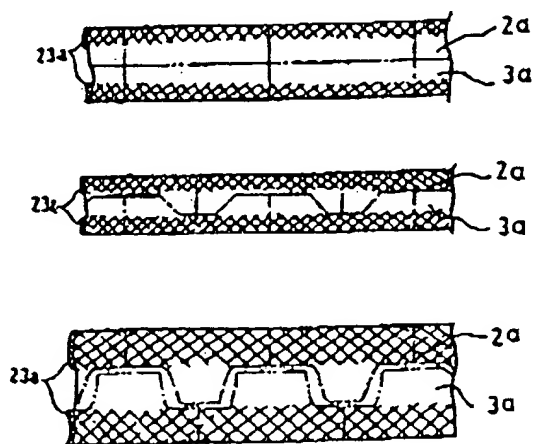
第1図(C)



第2図

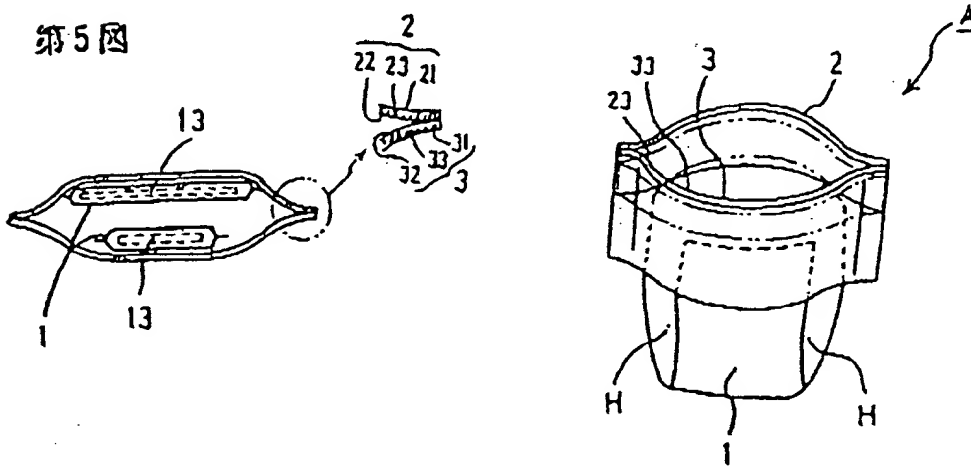


第3図



特許 3-176053 (6)

第 4 図



第 6 図

